Work Ord Tuesday, Marc			·	*980	739*						Page 1
Item ID: Revision ID: Item Name: Start Date:	.D2221-7 Rib 3/4/2013	Start Qty: 6.00	(8) *6*	Accept	*N900		100)* ፡	Setup Star Stop	I VI	S1* S2*
Required Date Reference:	e: 3/25/2013	Req'd Qty: 6.00	*6*		Customer:						
Approvals:	Process Pla	an:	Date: <i>[3-6</i> 3-c	Tooling: SPC (Y/N):		ate:		F	Run Star Stoj	1/1	R1* R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D2221	Rev	, н									
100		Large Fab		0.00				(2)		$\Gamma \cup \Gamma$	
Large Fab Large Fab			er dwg D2221 and remove identification	0.00 markings on tube					-34 13-	1°) -09- ×	3
110		QC6- Inspect dimension	ns to drawing	0.00					4	,	
110 QC Quality Control		Memo		0.00				81	N.	1_13	-10-0

120

Identify as per dwg & Stock Location: W4006 0.00

120 Packaging

ging Memo

Packaging

0.00

Bx Sy 13.10.01

										DQA:	Date:	
NCR:	Yes / N	lo			WORK ORDER NON-O	O	NFOR!	JANCE / UPI	DATE			
_										QA Closed:	Date:	"- "
Work Orde	or:				DISPOSITION		·		AGAINST DE	PARTMENT,	/PROCESS	
WOIK OIGE		•			Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is]		noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Work Order Update			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Dat	e Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	Ш											
Equip/Tooling	Ш											
Operator												
Material												
Setup	Ш											
Other	\square		ļ									
Process						ļ						
Supplier			ł									
Training	H											
Unapproved				L	<u>*************************************</u>	<u> </u>	T CATE	CORV		l	1	
Landi	ng Gear				r General	AUL	. CATE	3001				
Lanun	Bend	ng		<u> </u>	Bend		Grain			Ovalized	[Pressure/Forced
	\vdash	''៩ e Not Conce	entric to		BOM/Route	-	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack),	Broken/Damaged		4	ion Incomplete		Part Incorre		Weld
	Н.	ed/Crimped	1	-	Burrs	-	4 `	ions Incomplete/	Unclear	Part Lost/M	 	Wrong Stock Pulled
	Cuffs	-3/ 5 /200			Contamination		Mainte	•		Part Moved	- L	_
	Heat	Гreat			Countersink		Mislabe	eled		Positioned \	N rong	
		ction Strip i	n Tube		Cut Too Short		Misread			Power Loss,		Other
	—	es in Bend			Drill Holes		Offset		<u> </u>	,,,,		
	$oldsymbol{oldsymbol{ o}}$	e Waves in	Extrusio	n	Drawing		Out of 0	Calibration				•

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord Tuesday, Marci								Page 2				
Item ID: Revision ID: Item Name:	D2221-7			Accept	*N900	040	100)*	Setup	Start Stop	14	S1* S2*
Start Date: Required Date Reference:	3/4/2013 : 3/25/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:							
Approvals:	Process Pl	an:	Date:	Tooling:	D:	ate:	_		Run	Start	*N	R1*
Approvais:	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center I 130 *130*	D	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	/Qty	/ I	Reject Number	Insp. Stamp
QC Quality Control		Memo		0.00				1/3/	1 `\). } }	10,0	1 370 ⁻⁰

											DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORN	MANCE / UPDATE		QA Closed:	Date	e:	
W 10.1						DISPOSITION			AGAINS	ST DE	PARTMENT			
Work Orde	er: -					Rework	1		Skid-tube Crosstuk	ne 🗀	1	Water Jet	\neg	Engineering
Part N	No.					Scrap Use-as-is		ſ	Machining Small Fa	ab	4	d. Eng. Coor.		Quality Other
NCR N	No.		·			Work Order Update]		Large Fab Composi	_]	Supplier		
Root					Descri	ption of work order update	ļ	Initial	Action		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	1	QC Inspector
Doc/Data													İ	
Equip/Tooling	Ш											* .	ı	
Operator														
Material							ŀ					1	ĺ	
Setup						•							ļ	
Other	Щ					· ·	Ì							
Process	Ш			ļ										
Supplier	Ш													
Training	Ш													
Unapproved											<u> </u>	<u> </u>		
			· · · · · · · · · · · · · · · · · · ·				AUI	LT CATE	GORY					
Landi						General	_	٦			٦	Г		- /- /-
	-	Bending				Bend	-	Grain		<u> </u>	Ovalized		\neg	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric to	O/S	BOM/Route	\vdash	Hardwa		-	Over/Under	· · · · · · · · · · · · · · · · · · ·	-	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	<u> </u>	-	on Incomplete	-	Part Incorre	ł		Weld
		Crushed/	Crimped.		igspace	Burrs	\vdash	-1	ions Incomplete/Unclear	<u> </u>	Part Lost/M	-		Wrong Stock Pulled
İ		Cuffs				Contamination	<u></u>	Mainte			Part Moved			
	$\vdash \vdash$	Heat Trea				Countersink	\vdash	Mislabe		 	Positioned \			0.11
	-	Inspection	-	Tube		Cut Too Short	<u></u>	Misread	d	L	Power Loss/	'Surge		Other
	Ripples in Bend					Drill Holes	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Tuesday, March 05, 2013 1:41:44 PM

Work Order ID: 98039

98039

Parent Item:

D2221-7

D2221-7

Parent Item Name:

Rib

Start Date: 3/4/2013

Required Date: 3/25/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 08-12-02 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	1,350.211	4.6042	29.07916			
M304TS0	750W	065							**	SAD	13-	39-3	ø

304, SQ Tube .75x.75x.065W

Loc Code Location Loc Qty MAT017 973.158 973.158 124069 WA006 377.053297 123303 377.053297

NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UP	DATE	QA Closed:	Date	· ::
Work Orde	er:				DISPOSITION Rework	1		Skid-tube	AGAINST DE	PARTMENT	/PROCESS Water Jet	Engineering
Part N	lo				Scrap Use-as-is Work Order Update			Machining noforming Large Fab	Small Fab Finishing Composite	4	d. Eng. Coor e/Packaging Supplier	Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Init Chief			tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						351						
	1	·	<u></u>	<u> </u>	F	AULT	CATE	GORY	·			
Landin	Cracks Crushed, Cuffs Heat Tre	n Strip in		OLG STORY VAS CONTROL VAS CONTROL RANGE STORY RANGE ST	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	Hall In In M	struct lainte islabe isreac	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
}	Ripples i	n Bend Vaves in E	Extrusio	n	Drawing	Offset Out of Calibration			<u></u>			

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

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ITEM QTY \mathbb{A} P/N DESCRIPTION х D2221 **BASKET BASE ASSEMBLY (AS350)** D2221-1 2 D2221-5 RIB 3 D2221-7 RIB 2 D2232-3 BASKET HINGE 5 D2235-1 RIB 6 2 D2581 MOUNTING BRACKET 2 2 D3442-1 SHIM 9 2 D3825-041 RIB ASSY (BASKET END) 10 2 D3826-041 RIB/GUSSET ASSY RIB ASSY (INBOARD) 11 1 D3827-041 12 2 D3833-1 MESH, BASE END FACE D3832-1 MESH (BASE) 13 1 D2221 BASKET BASE ASSEMBLY (AS350) (MESH SHOWN LOCALLY FOR CLARITY) REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1), REVISED SECTIONS A-A, B-B AND C-C (ZN G-3, C-2-3 NP G-3), REVISED DETAIL D (ZN B7-4); ADDED DETAIL B (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-16-F, (SN EET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/02327-3, D3826-041 REPLACES D2225-103827-041 REPLACES D2221-10 NIBOARD SIDE; ADDED D3832-1 AND D3833-1, REASON: SATISFY "LEAN MANUFACTURING" PROGRAM. 08.09.18 MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL:
TOLERANCE FOR 96.00 JIM WAS +-0.01 AND 56.00 JIM
WAS REF (270 B8-2); 19.02 JIM WAS "HARD" DIMENSION IS
NOW "REF" (2N B4-2); NOTE 5 TRANSFERED FROM SHT 1
TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING
TRANSFERED TO "B" FORMAT AJS 08.06.16 ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET 05.06.07 F РН Ε CHANGE HINGE CP 01.04.19 D CHANGE LATCH BW 96.06.21 С SEPARATE BASKET AND LID 95.11.21 KH REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD NOTES: 1) MATERIAL: N/A DRAWN HAWKESBURY, ONTARIO, CANADA 1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED DRAWING NO. CHECKED REV. H D2221 MFG. APPR. SHEET 1 OF 5 APPROVED TITLE 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX BASKET BASE ASSEMBLY (350) NTS 6) IDENTIFICATION: N/A DE APPR. 8) WEIGHT: 42.00 lbs APPROX 9) MASK ALL HOLES PRIOR TO POWDER COATING COPYRIGHT ⊕ 1994 BY DART AEROSPACE LTD

In is equate and contremal and is supplied on the Europes condition that it is
set of the and the condition of the co DATE 08.09.18

D

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	-COI	NFORN	MANCE / UPDATE		•		
					· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date:	
Work Orde	ar:				DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS	
WOIK OIGE					Rework	¬		Skid-tube Cross	stube		Water Jet	Engineering
Part N	lo.				Scrap		į.	├	II Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therm	noforming Fini	shing	Rec/Stor	e/Packaging	Other
NCR N	lo				Work Order Update			Large Fab Comp	oosite		Supplier	
Root				Descri	otion of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data		•										
Equip/Tooling											•	
Operator			,		,	1.	•					
Material												
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Other												
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Supplier					in the second	•		•				1
Training												
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Landir	ng Gear				General		_					
1	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to	o/s ^{- [a-}	BOM/Route	· L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			:39	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.		ļ	Burrs	· L:	Instruct	ions Incomplete/Unclear		Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance ·		Part Moved		
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	-
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
Ī	Ripples in	Bend			Drill Holes		Offset					

Out of Calibration
Out of Sequence

Outside Dimensions

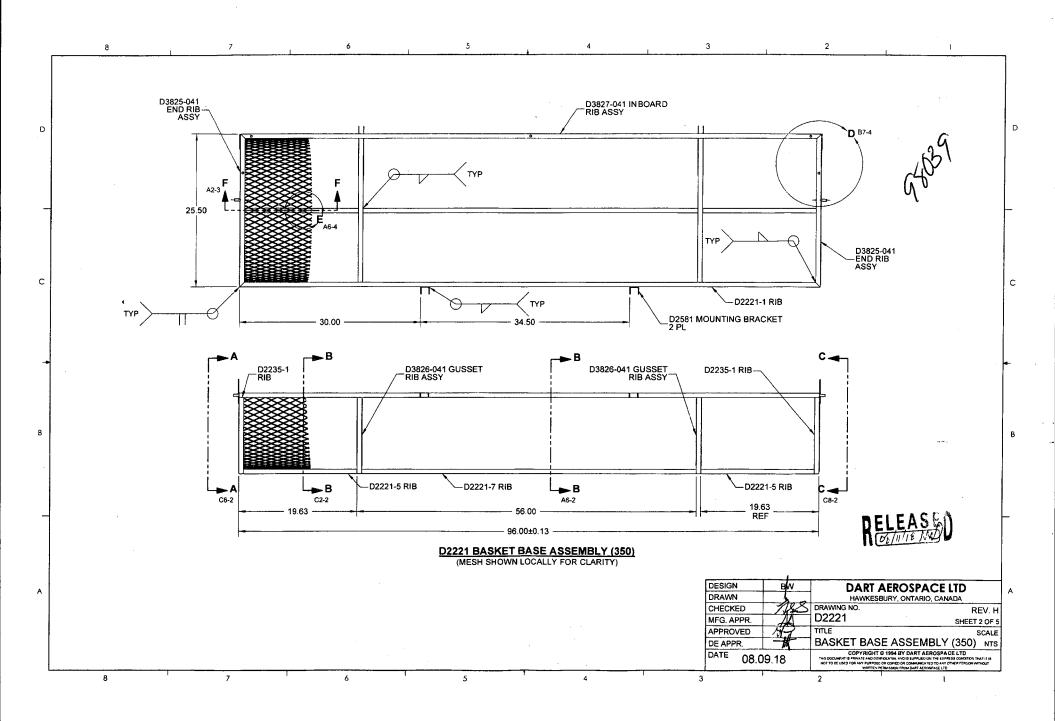
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

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											DQA:	Date:	
NCR:	Yes /	No				WORK ORDER NON-	100	NFOR	MANCE / UPDATE			D	
						I			•		QA Closed:	Date:	
Mork Ord	٥					DISPOSITION			AGAINST	r DE	PARTMENT/	PROCESS	
Work Ord	er:	_	-411		· · · · · · · · · · · · · · · · · · ·	Rework	7		Skid-tube Crosstube			Water Jet	Engineering
Part I	Vο					Scrap	1		Machining Small Fat	-	Prod	d. Eng. Coor.	Quality
	···-					Use-as-is	1		noforming Finishing	\vdash	1	e/Packaging	Other
NCR I	No.					Work Order Update			Large Fab Composite	-	-	Supplier	
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Root					l	ption of work order update	1	nitial	Action		Sign &		
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	Cuf					Contamination	\vdash	-		\vdash	4	Vrong	
	Heat Treat					Countersink Mislabeled					Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

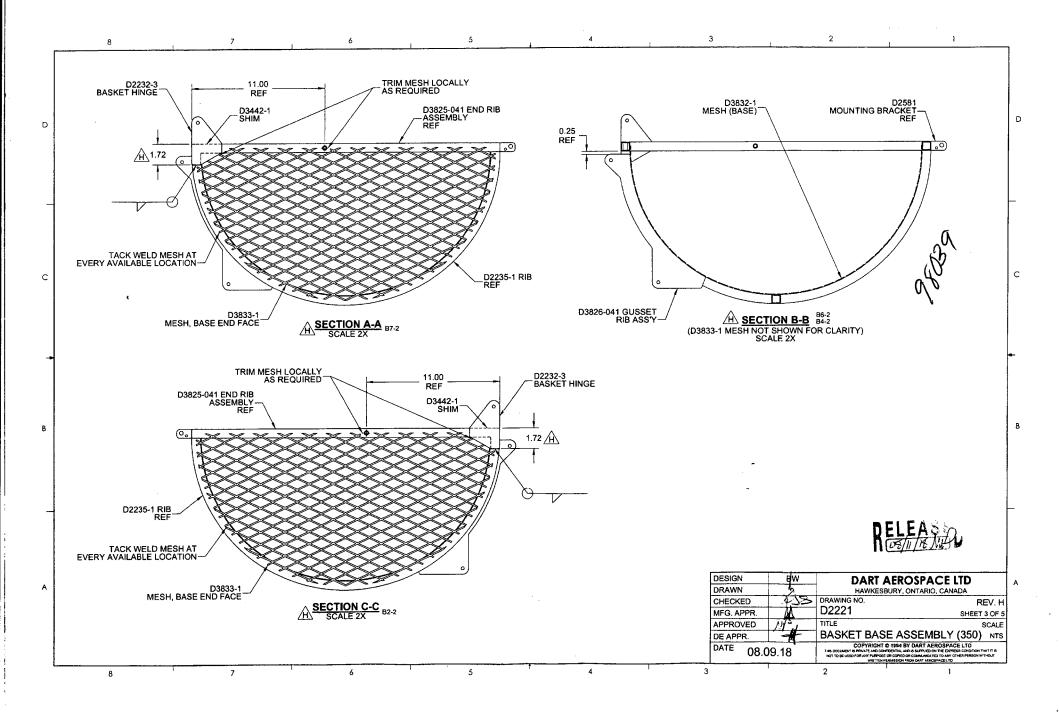
Torque Waves in Extrusion

Cut Too Short

Drill Holes

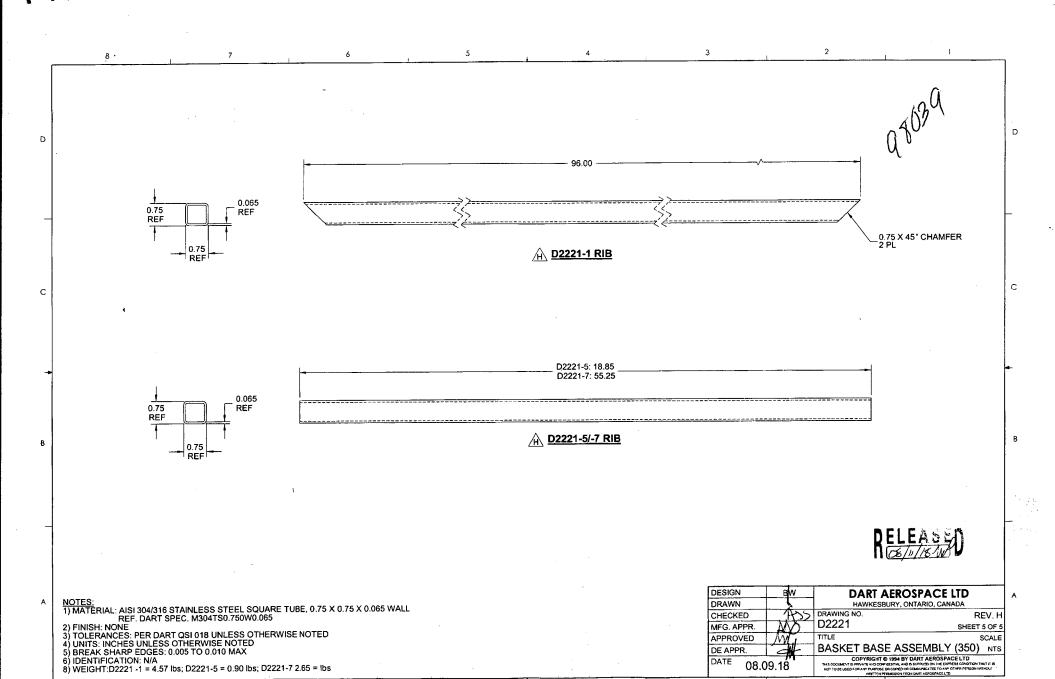
Drawing

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NCR:	Yes	1	No
INCN.	162	/	NO

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											DQA:	Date:	
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											QA Closed:	Date:	
						DISPOSITION				AGAINST D	EPARTMENT/	/PROCESS	
Work Orde	er:					Rework	- I		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
1 41 61						Use-as-is	7		noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	10					Work Order Update			Large Fab	Composite		Supplier	
Root			1		Descri	ption of work order update	 	nitial	Act	tion	Sign &		
Cause] [Date	Step	Qty	i	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Jnapproved				<u>1</u>									
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Landii	ng Gea				<u> </u>	General Bend		Grain		Г	Ovalized	Г	Pressure/Forced
	_	nding	ot Concer	atria ta C	\(\rightarrow \ri	BOM/Route	-	Hardwa	uro.	-	Over/Under	tolerance	Temperature/Cure
			ot Concer	itric to C)/3	Broken/Damaged	\vdash	1	ion Incomplete	-	Part Incorre		Weld
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	Cu		липрей.		-	Contamination		4	enance		Part Moved		
	-	iis at Trea	+		\vdash	Countersink	-	Mislabe		<u> </u>	Positioned V	Wrong	
			n Strip in	Tube	infe	Cut Too Short	-	Misrea		ŀ	Power Loss/	_	Other
	Rir	ples in	Rend	Tube	7 +	Drill Holes	\vdash	Offset	-	L		J	
			aves in E	xtrusion	, <u> </u>	Drawing	<u> </u>	4	Calibration				
	_		equence			Finish		4	Sequence				
		-	ist in Tuk			Folio		+	Dimensions		···		



DQA:	Date:	
-		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCK.	es / NO				WORK ORDER NOW		VIANCE / OI DATE	QA Closed:	Date:	
Work Orde	er:		÷		DISPOSITION	1 -		ST DEPARTMENT,	/PROCESS Water Jet	Engineering
Part N	lo				Rework Scrap Use-as-is		Skid-tube Crosstub Machining Small Fa noforming Finishir	ab Pro	d. Eng. Coor.	Quality Other
NCR N	lo				Work Order Update]	Large Fab Composit	· ·	Supplier	
Root				Descr	ption of work order update	Initial	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Description	Date	Verification	QC Inspector
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quip/Tooling									`	
Operator										,
Material						1				
Setup										
Other										
Process										
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	Bending			. –	Bend	Grain		Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to (^{D/S}	BOM/Route	Hardwa		Over/Under	⊢	Temperature/Cure
:	Cracks				Broken/Damaged	—	ion Incomplete	Part Incorre	 	Weld
	Crushed/	Crimped.		\vdash	Burrs		tions Incomplete/Unclear	Part Lost/M		Wrong Stock Pulled
}	Cuffs			<u> </u> _	Contamination	\vdash	enance	Part Moved		
}	Heat Trea			_	Countersink	Mislabe		Positioned \		7045
	Inspectio		Tube		Cut Too Short	Misrea	ď	Power Loss,	Surge	Other
1	Ripples in				Drill Holes	Offset	- W			
	Torque W			` _	Drawing	 	Calibration		0 V	
ļ	Turning S			ļ	Finish	\blacksquare	Sequence		· · · · · · · · · · · · · · · · · · ·	
	Wave/Tw	ist in Tub	oe e		Folio	Outside	e Dimensions		* *	

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